

Work Order ID 78617

January-11-12 2:51:30 PM

78617

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Item ID: D2493 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Patient Stop Assembly
 Start Date: 11/01/2012 Start Qty: ~~6.00~~ ⁵ ***6*** Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2493	Rev B								

100
100
 Small Fab
 Small Fab
 Small Fab

Small Fab
 Memo
 Assemble as per Dwg D2493.

0.00
 0.00

Ep 12/02/15 (5)

110
110
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O
 Memo

0.00
 0.00

5/12/02/15

(XJ)

120
120
 Packaging
 Packaging

Identify as per dwg & Stock Location: 224
 Memo

0.00
 0.00

12/1/6 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78617***78617***

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Item ID: D2493

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Patient Stop Assembly

Start Date: 11/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00


130

QC

Memo

0.00

Quality Control

 M.L.S 12/02/17012-02-14
(3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Work Order ID: 78617

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Parent Item: D2493

D2493

Parent Item Name: Patient Stop Assembly

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C03.01.17Reformat; Incorporated D2492KJ/RFIPP Rev:D
10.09.24 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2492 *D2492* Patient Stop		Manufactured	No			100	Each	0.0000	1	6		EP 12/02/15	
D2444 *D2444* Pip Pin Assembly		Manufactured	No			100	Each	13.0000	2	12		EP 12/02/15	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				GA			6						
				77689			6						
				ST014			7						
				72147			7						
MS27039-1-07 *MS27039-1-07* Screw		Purchased	No			100	Each	88.0000	2	12		EP 12/02/15	
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST291			88						
				18106			88						

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D2493

D2493

Parent Item Name: Patient Stop Assembly

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

100

Each

3,266.000

2

12

NAS1149D0363.I

Washer

**

EP 12/02/15

Location

Loc Qty

Loc Code

ST298

3266

117601

61

118077

1

118612

18

118968

26

119537

1160

120142

2000

10

MS21042L3

Purchased

No

100

Each

6,081.000

2

12

MS21042I 3

Nut

**

EP 12/02/15

Location

Loc Qty

Loc Code

ST300

6081

117441

16

117885

32

118451

5

118927

3

119017

5551

119075

474

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

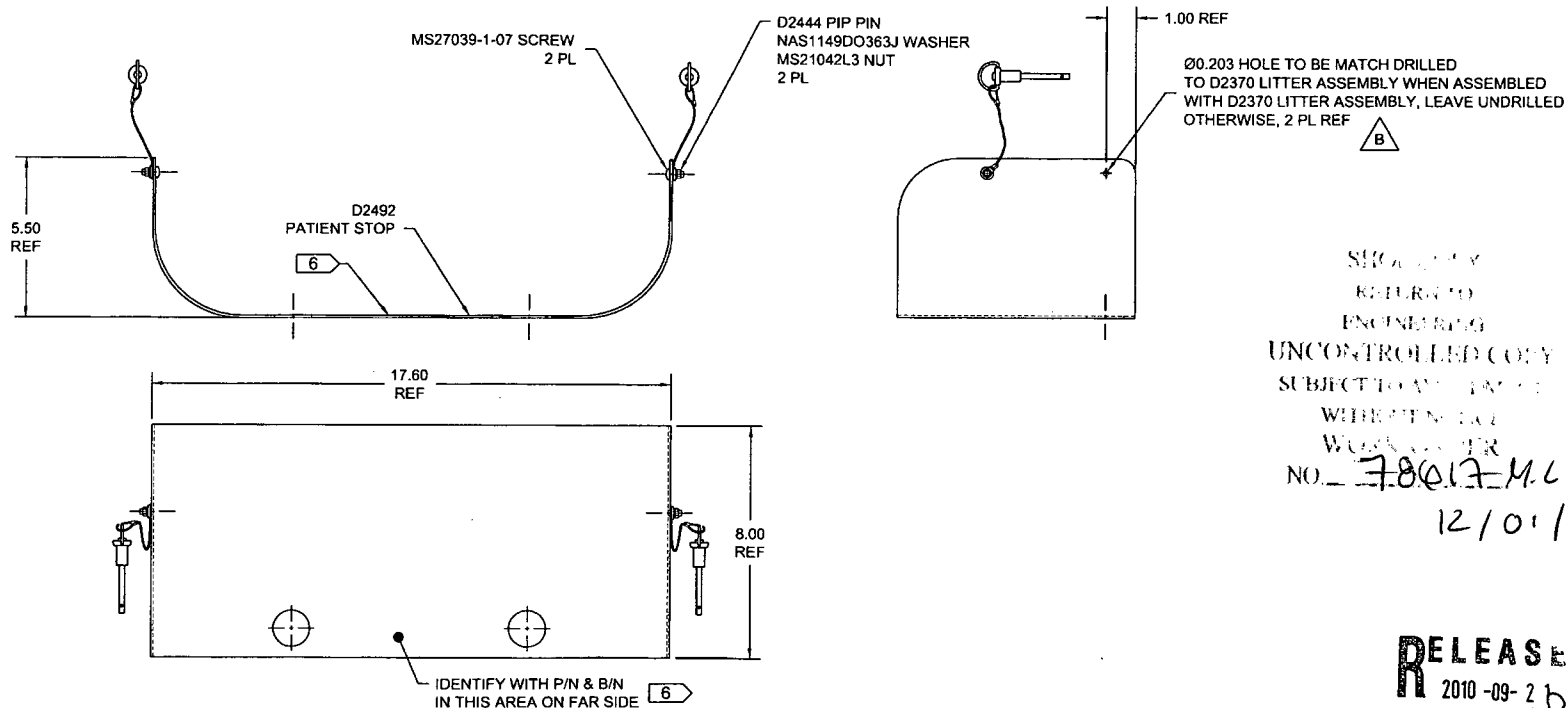
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D2493	PATIENT STOP ASSEMBLY
2	1	D2492	PATIENT STOP
3	2	D2444	PIP PIN
4	2	MS27039-1-07	SCREW
5	2	NAS1149DO363J	WASHER (OR AN960JD10)
6	2	MS21042L3	NUT (OR MS21042-3)



D2493 PATIENT STOP ASSEMBLY

NOTES:

- 1) MATERIAL: SEE PARTS LIST
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2493" AND B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 1.7 lbs

STANDARD
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK CENTER
NO. 78017-4.6.5
12/01/11

RELEASED
2010-09-21

B	REDRAW, HOLE NOW DRILLED (D2-1, NCR10-062)	CP	10.08.10
A	NEW ISSUE	BW	95.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	BW		
DRAWN	9P		
CHECKED	9P		
MFG. APPR.	9P		
APPROVED	9P		
DE APPR.	9P		
DATE	10.08.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D2493 SHEET 1 OF 1
TITLE SCALE
PATIENT STOP ASSEMBLY NTS

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